

Work Order ID 50129

July 8, 2009 11:50:05 AM

Page 1

Item ID: D2512

Accept

Revision ID: E

Item Name: Basket Lid 205/350

Start Date: 7/09/09

Start Qty: 1.00

Required Date: 7/24/09

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 2-Cut (4) D2236 From
D3166-3 3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

□

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as
required

~~3-11-2009~~ 4109213

SAD 09.07.09 ①

SY 09/07/14

1x

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control



Pl 09.07.14








Work Order ID 50129

July 8, 2009 11:50:05 AM

Page 2

Item ID: D2512	Accept		Setup	Start	
Revision ID: E					
Item Name: Basket Lid 205/350				Stop	
Start Date: 7/09/09	Start Qty: 1.00			Cust Item ID:	
Required Date: 7/24/09	Req'd Qty: 1.00			Customer:	
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00	=> 807/14						
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo pressure wash 1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat COAT: START TIME: 7:30AM 400F OVEN TEMPERATURE: 7:50AM FINISH TIME: 8:00AM 2ND COAT: START TIME: 8:30AM OVEN TEM 400F M112148 09-07-15	0.00 0.00	09-07-14						
140  HandFinish Hand Finishing	HandFinishing Memo Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: M11013	0.00 0.00	UMP 09/07/10						

Work Order ID 50129

July 8, 2009 11:50:05 AM



Page 3

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 7/09/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

BR 09-07-16

0.00

Quality Control

160

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

5082

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/21 JF

U 09.07.17

Picklist Print

July 8, 2009 11:50:05 AM

Page 1

Work Order ID: 50129

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350

Comments:

Start Date: 7/09/09

Required Date: 7/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2232-1RevC

Manufactured

No

100

Each

12.0000

2.0000



Basket Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

48230

12

D2327-1RevD

Manufactured

No

100

Each

20.0000

2.0000



Spacer Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

46325

20

D2506RevF

Manufactured

No

100

Each

5.0000

1.0000



Label Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

44275

1

48607

4

2x SY 09/07/13

2x SY 09/07/13

1x SY 09/07/13

Picklist Print

July 8, 2009 11:50:05 AM

Page 2

Work Order ID: 50129

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350

Start Date: 7/09/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2581RevA1

Manufactured

No

100

Each

35.0000

2.0000



Mounting Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

35

46086

2

48428

33

D3166-3RevA1

Manufactured

No

100

Each

0.0000

1.0000



Basket Hoop

M304EX0.75-16F

Purchased

No

100

sf

818.0437

18.0000



Expanded Metal Flat SS

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

818.0437

108152

90

110134

6.7

110292

14.4

110629

14.41

110861

21.18

110992

0.58

111444

17.79

111630

35.15

111956

36.36

112147

581.4737

2x *SY 09/07/13*
SAD 09-07-14

2.00
16.00 *SAD 09-07-09 ①*

July 8, 2009 11:50:05 AM

Shop Packet Print

Page 2

Picklist Print

July 8, 2009 11:50:05 AM

Work Order ID: 50129

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350

Comments:

Start Date: 7/09/09

Required Date: 7/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	463.0861	45.8741			



304 SQ Tube .75x.75x.065W



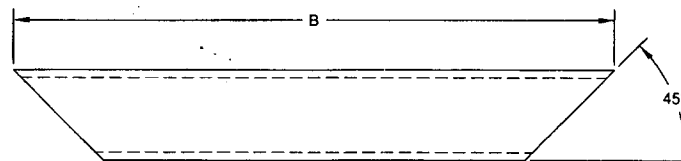
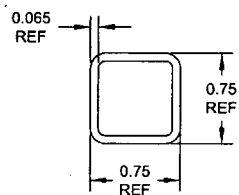
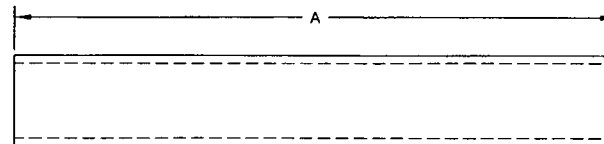
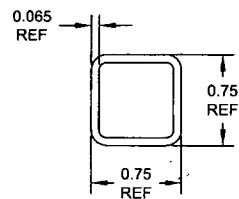
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	463.0861	
110969	3.29	
111148	15.96	
111331	1.96	
111432	0.44	
111885	25.14	
112051	416.2961	

5.00
40.8741 SAP 09-07-09 ①

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

W/O
50129



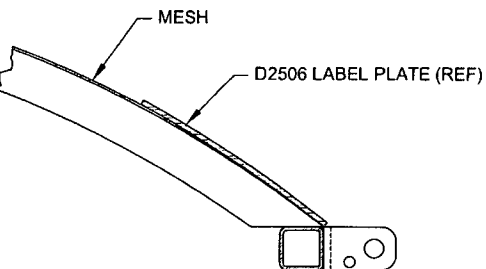
RELEASED
08-06-21/11

E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

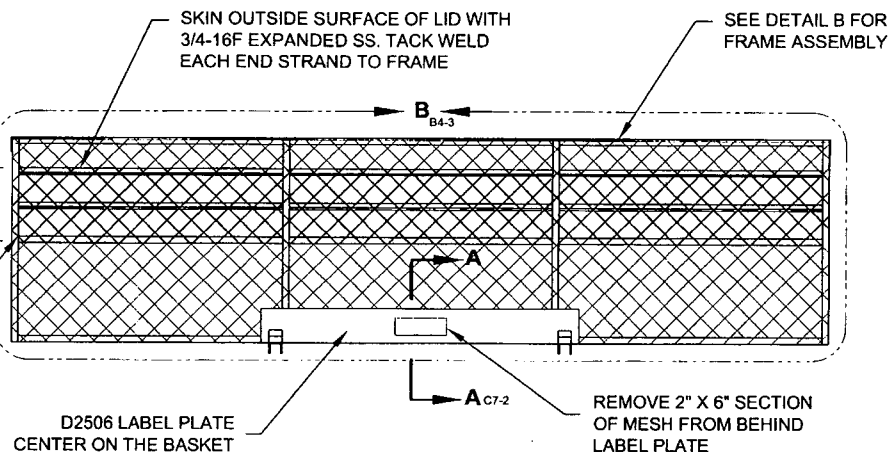
E	INCORPORATED D1 & D2 MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION. ADDED MEMBERS. INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



D2512 BASKET LID ASSEMBLY NOTES:

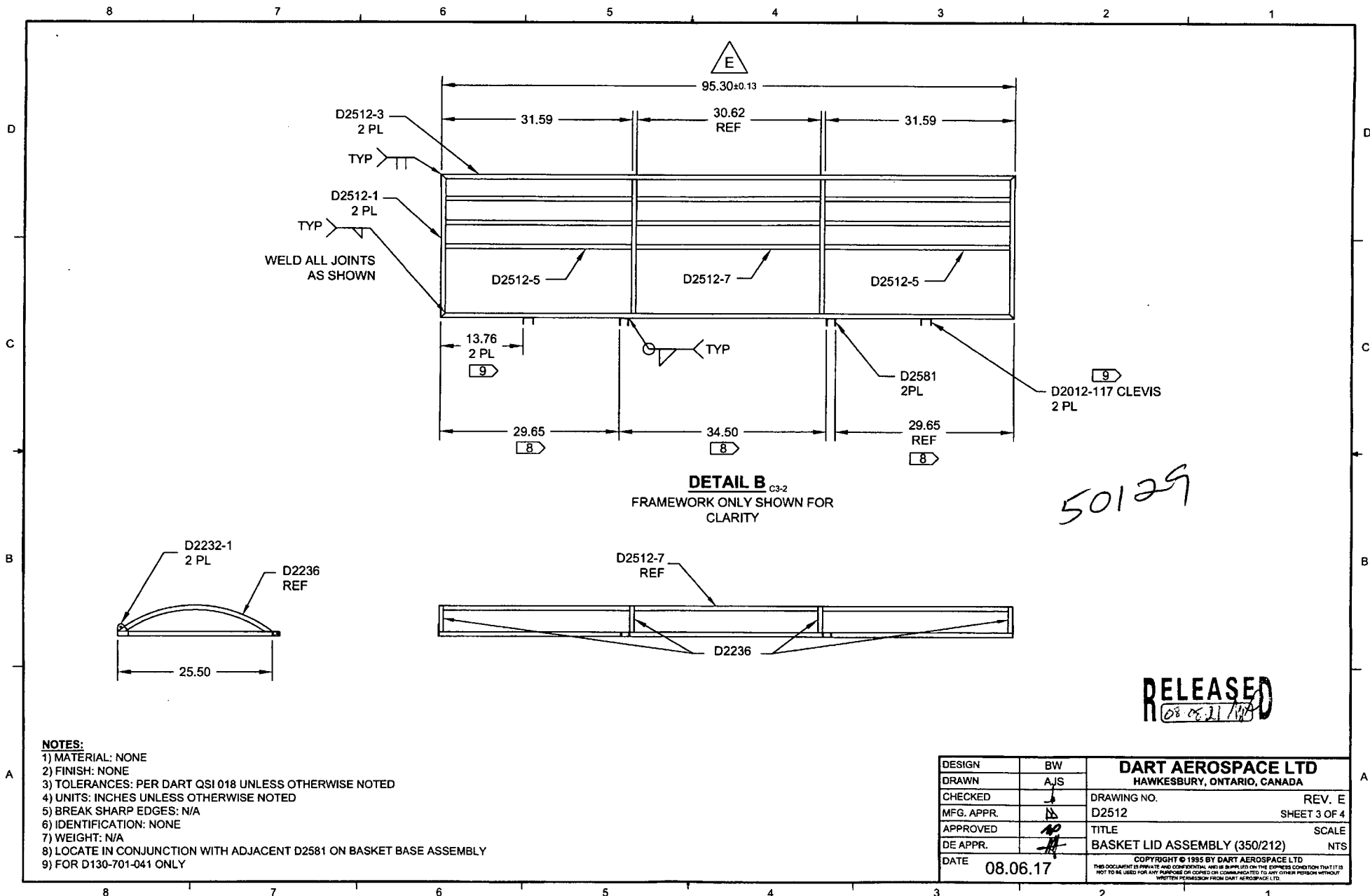
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



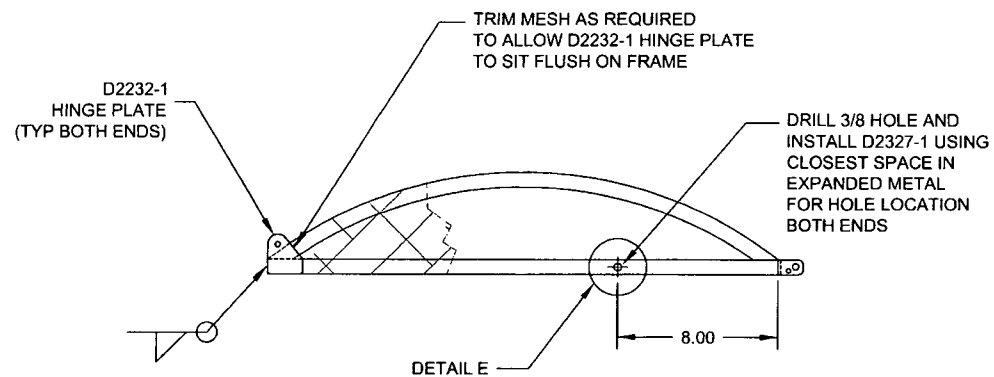
50129

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08.06.17

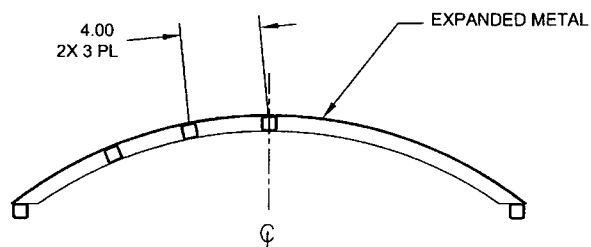
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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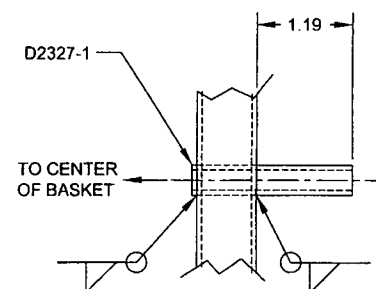
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

50129

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1